

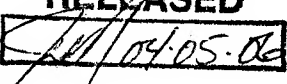
5/25

DART AEROSPACE LTD	Work Order:	23311
Description: Console Side LH (206 Hi-Slope)	Part Number:	D2602-1
Note: Issue with Part Number D2602-2		
Dwg: D2602 Rev. A1	Qty:	5 10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	JS	05.05.20	10
2	MV	Cut Blank per template DT8243 Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>M17437</u>	EC	05.06.20	10
3	MV	Machine as per Folio FA145 and Dwg D2602 Stack of 10 Identify as D2602-1	SD	05.06.20	5
4	QC2	Inspect parts as they come off the CNC machine	SD	05.06.20	5
5	QC8	Second check	EC	05/06/27	5
6	GA	Deburr	FF	05.06.28	5
7	GB	Form as per Dwg D2602	J	05-06-28	5
8	QC5	Inspect work to Step 7	SB	05/06/28	5
9	FP	Acid etch and Alodine as per QSI 005 4.1	FF	05.06.29	5
10	QC3	Inspect work to Step 9	SB	05/06/29	5
11	ST	Identify and Stock	SB	05/06/29	5
12	AC	Cost / part <u>18.20</u>	SAC	05.06.30	5
13	DC	Close W/O <u>18.25</u> Inspect Level 21	JS	05.07.05	5

P70

Rev	Date	Change	Revised By	Approved
A	96.07.27	New Issue		
B	98.05.08	Added drawing revision	KB	
C	98.11.25	Added Inspection Levels	DM	
D	04.02.25	Reformat	KJ/RF	

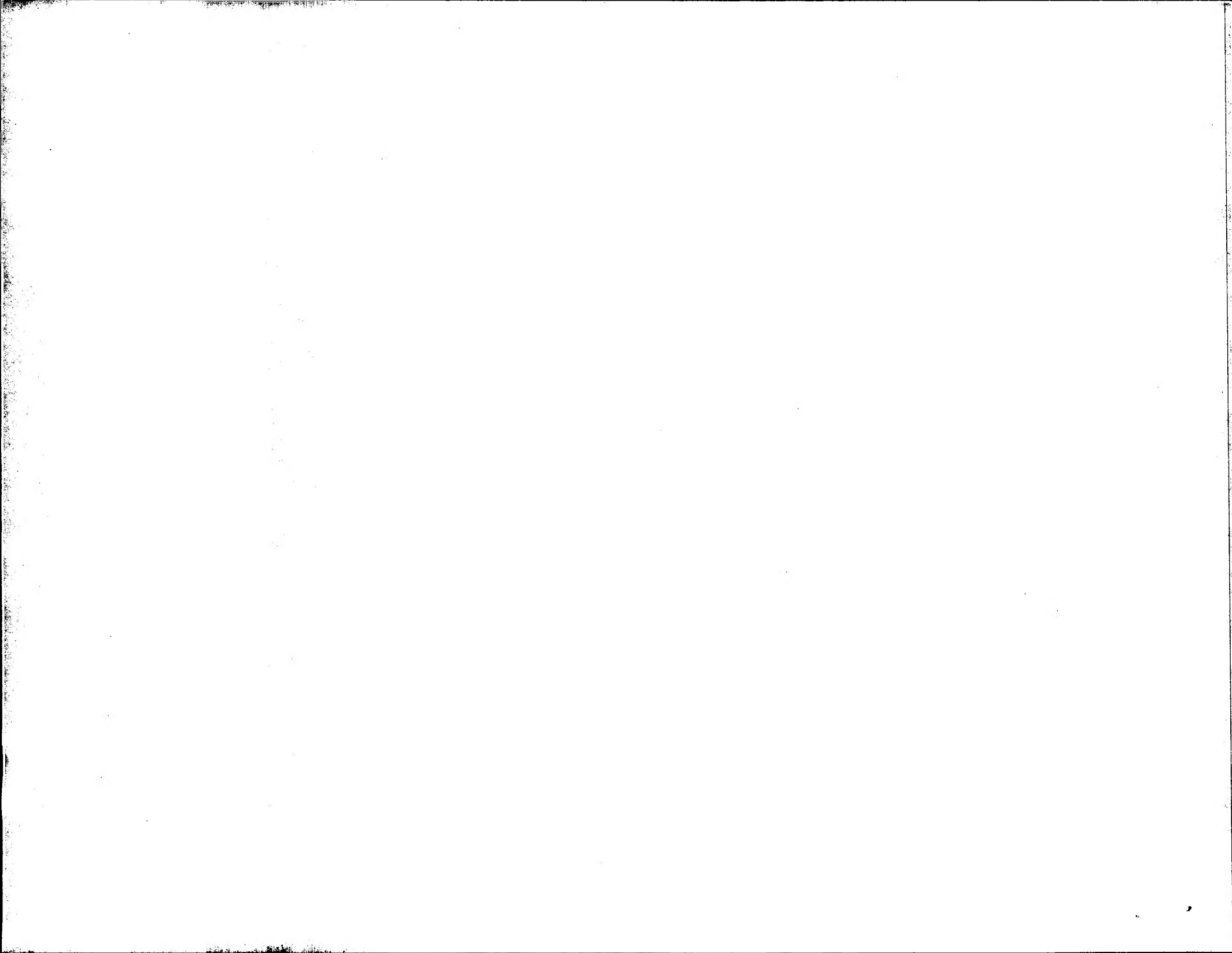
RELEASED

 04.05.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 233113		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-20	3	5x 02602-1 folio not clear for dowel pin location. Parts machined to high up and bottoms came up short		Scrap: destroy Ensure dowel pin location is clearly indicated from folio to base plate	 05.06.20	 05.06.20		 05-06-20

Part No: DZ602-1 PAR #: _____ Fault Category: Prod/machina ^{parts} NCR: Yes No DQA: Date: 05/07/05

NOTE: Date & initial all entries QA: N/C Closed: Date: 05.07.05

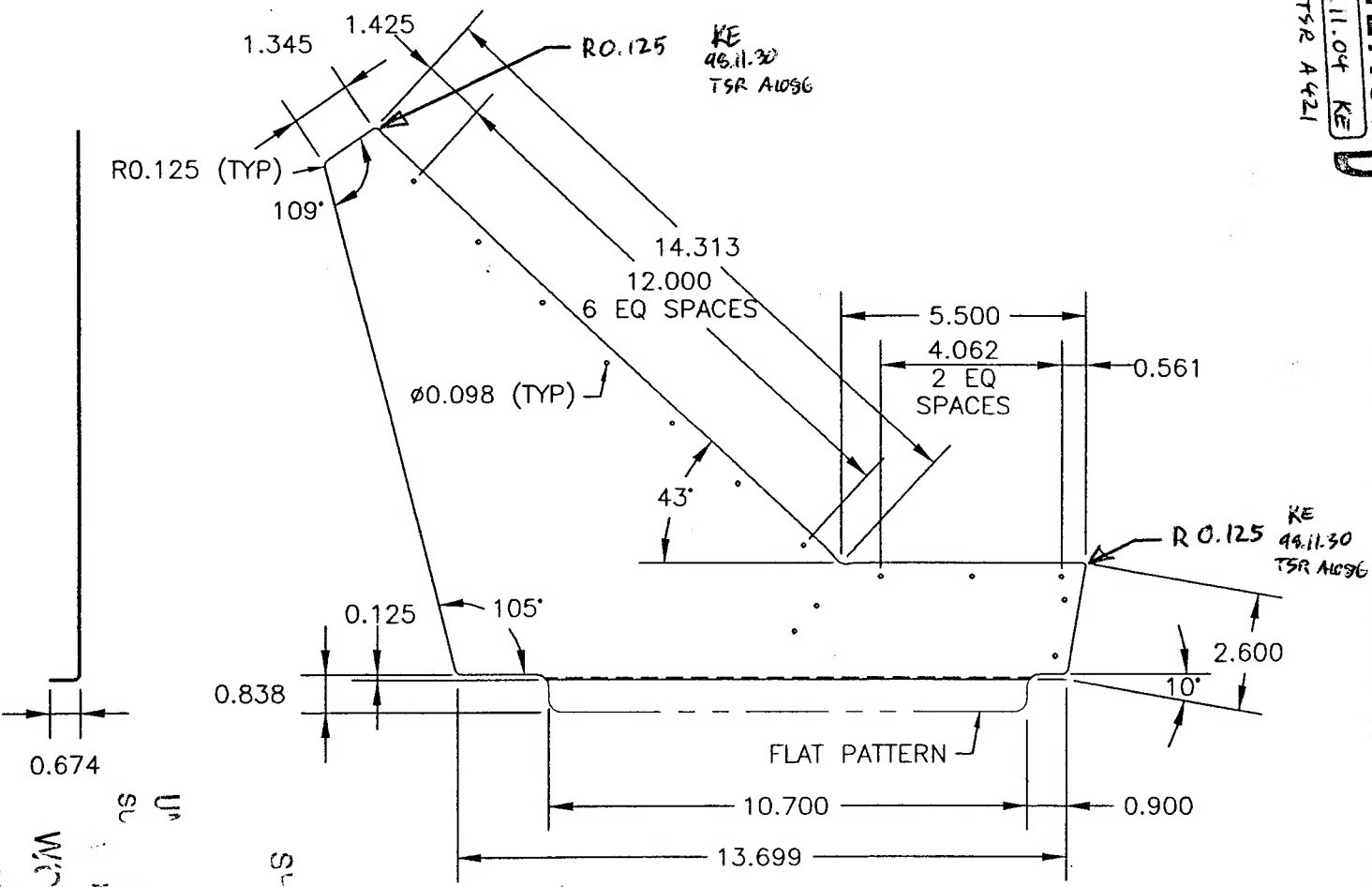


DART

QA CONTROL

RELEASED
97.11.04 KE
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED KE	APPROVED B3	DRAWING NO.	REV. A
DATE 97.10.22		D2602	SHEET 1 OF 1
		TITLE CONSOLE SIDE	SCALE 1:4
A	97.10.22	D2602 WAS D206-547-21/-22	
AI	02.06.04	ADD FINISH	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
 PROFILE CONTROLLED BY FOLIO H2602
 BEND RADIUS 0.093
 FINISH: CHEMICAL CONVERSION COAT PER PART Q51 & 5 4.1 **AI**
 D2602-1 SHOWN
 D2602-2 OPPOSITE

W/C ORDER
 NO. 23311
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 SUCCE COPY

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 12, 2005
04:28 pm

Work Order No : 0023311
Project Name : D2602-1
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : D2602-1
Description : Console Side Hi Slope
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 05-12-05
Est Finish Date : 06-23-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00